

Date: Tuesday, 17/02/2009 10:18:59 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: WEARSHOE
<b>Job Number</b>	: 45824		
<b>Estimate Number</b>	: 12786		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D35645
<b>This Issue</b>	: 17/02/2009	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D3564 REVD
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 44658	<b>Drawing Revision</b>	: D
	<b>Type</b> : SMALL /MED FAB	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 23/02/2009
<b>Checked &amp; Approved By</b>	: <u>JLD 09.02.17</u>	<b>Qty:</b>	12 Um: Each
<b>Comment</b>	: Est Rev:A New Issue 07-03-08 ec : Est Rev:B As per Rev C 07-07-09 JLM : Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC : Est Rev D added DT# 08.04.21 DD Verified by EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S16GA	304/316 Sheet .063
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**Comment:** Qty.: 1.5750 sf(s)/Unit Total : 18.9000 sf(s)  
 M304S16GA Stainless steel sheet 0.063" thick  
 Batch: 110551 RB 9-2-26

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3564  
 Dwg Rev: P  
 Prog Rev: D RB 9-2-26

(12)

2-Deburr if necessary RB 9-2-26

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

509/02/27 (12)

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE  
 Deburr if necessary  
 Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155

509/03/03 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 17/02/2009 10:18:59 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 45824

Part Number: D35645

Job Number:



Seq. #:

Machine Or Operation:

Description :

Form Joggle as per Dwg D3564 on brake using Jig DT8157

CP 09/03/03 (12)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

S 09/03/03 (12)

7.0

POWDER COATING

POWDER COATING



m 109648



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

(12)

START TIME:

7:00

OVEN TEMPERATURE:

320°

FINISH TIME:

7:30

FL 09/03/04

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-03-4 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-19

BR 09-03-4 (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/05

Job Completion



U 09.03.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> W5824
<b>Description:</b> Wearshoe		<b>Part Number:</b> D3564-5
<b>Inspection Dwg:</b> D3564 <b>Rev:</b> D		<b>Page 1 of 1</b>

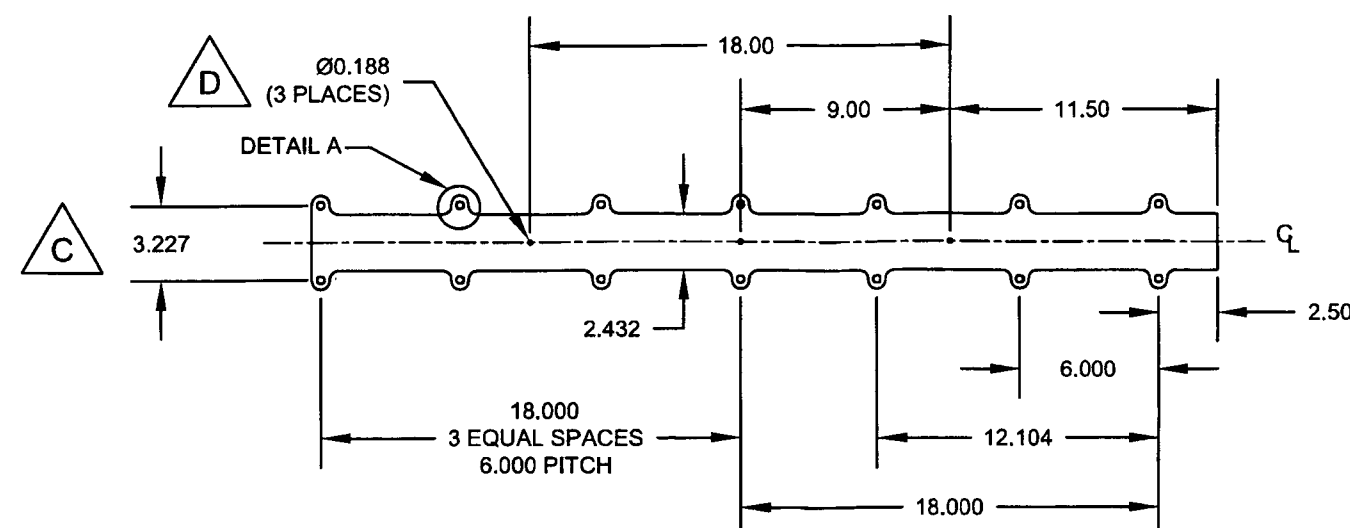
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
43.50	+/-0.030	43.50	X			
6.75	+/-0.030	6.750	X			
10.00	+/-0.030	10.00	X			
20.00	+/-0.030	20.00	X			
30.00	+/-0.030	30.00	X			
2.50	+/-0.030	2.50	X			
3.227	+/-0.010	3.229	X			
38.500	+/-0.010	38.560	X			
5.500	+/-0.010	5.500	X			
2.50	+/-0.030	2.50	X			
2.432	+/-0.010	2.434	X			
0.300 x 0.300	+/-0.010	305 X 306	X			
Ø0.188	+0.005/-0.001	.192	X			
R0.375	+/-0.010	.375	X			
0.063	+/-0.010	.060	X			

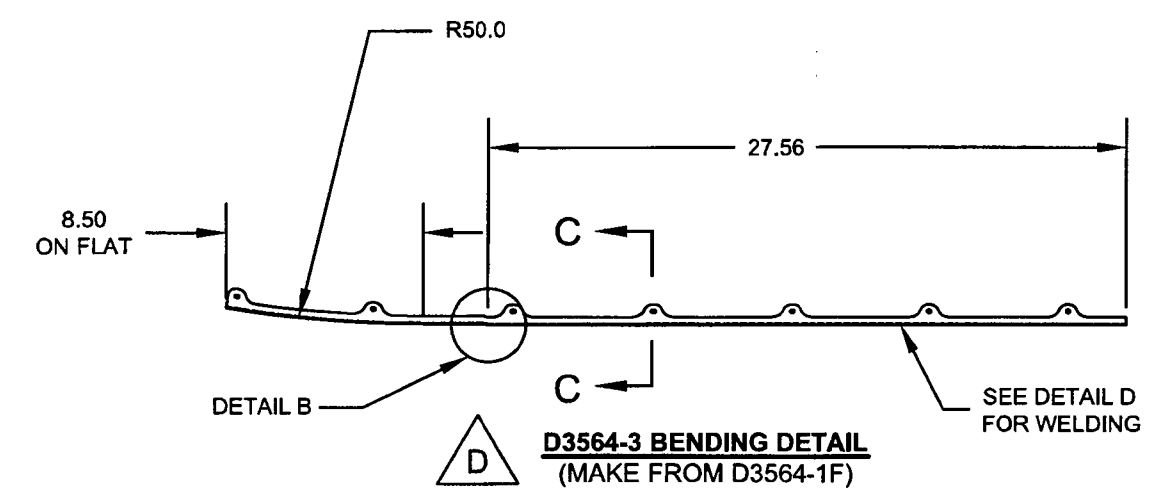
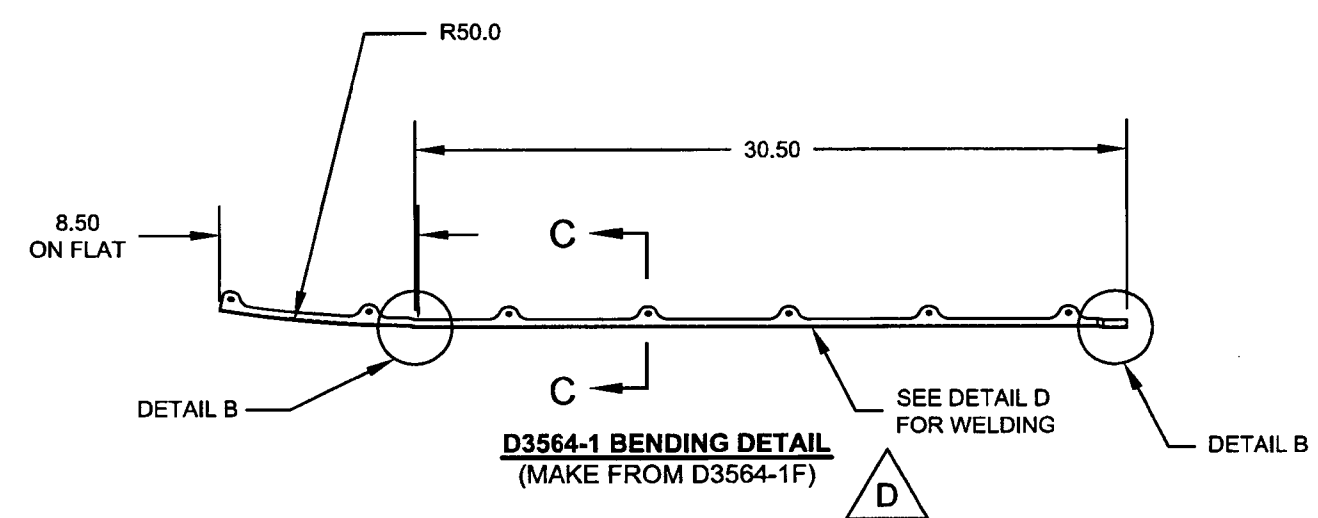
<b>Measured by:</b> B	<b>Audited by:</b> S	<b>Prototype Approval:</b> N/A
<b>Date:</b> 9-2-26	<b>Date:</b> 09/02/27	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	DD



**D3564-1F FLAT PATTERN**

**RELEASED**  
07.09.04



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NO. 45824

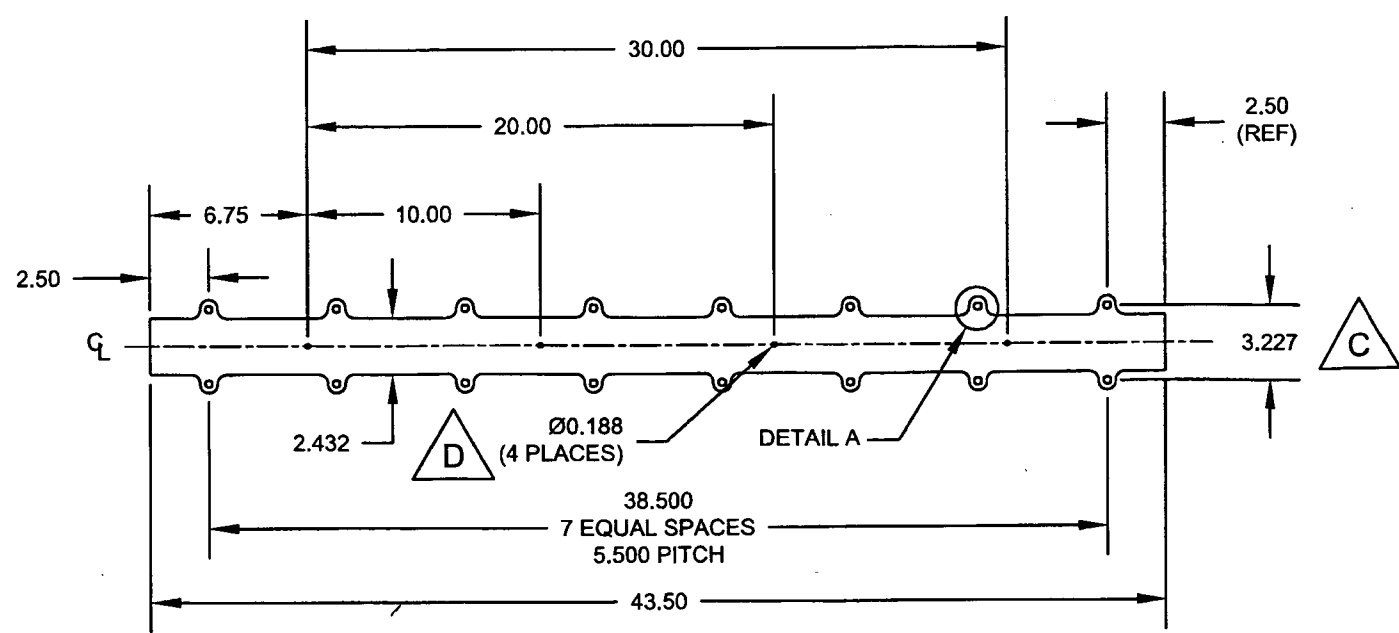
- D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
  - 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: SEE TABLE IN ZONE A3
  - 8) WELD PER DART QSI 004
  - 9) SEE PG 3 FOR SECTIONS AND DETAILS
  - 10) PARTS ARE SYMMETRIC ABOUT Q

**WEIGHTS:**

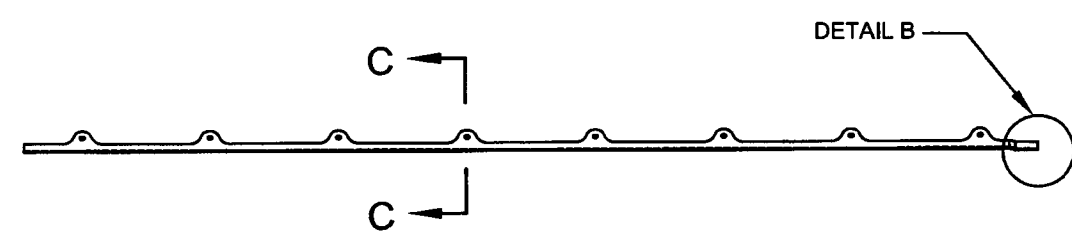
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
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MFG. APPR.	PH	D3564	SHEET 1 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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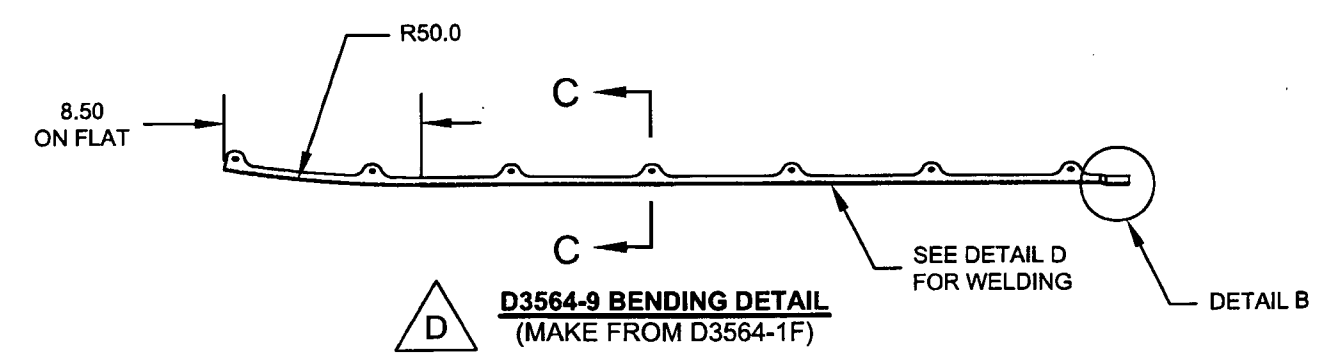
8 7 6 5 4 3 2 1



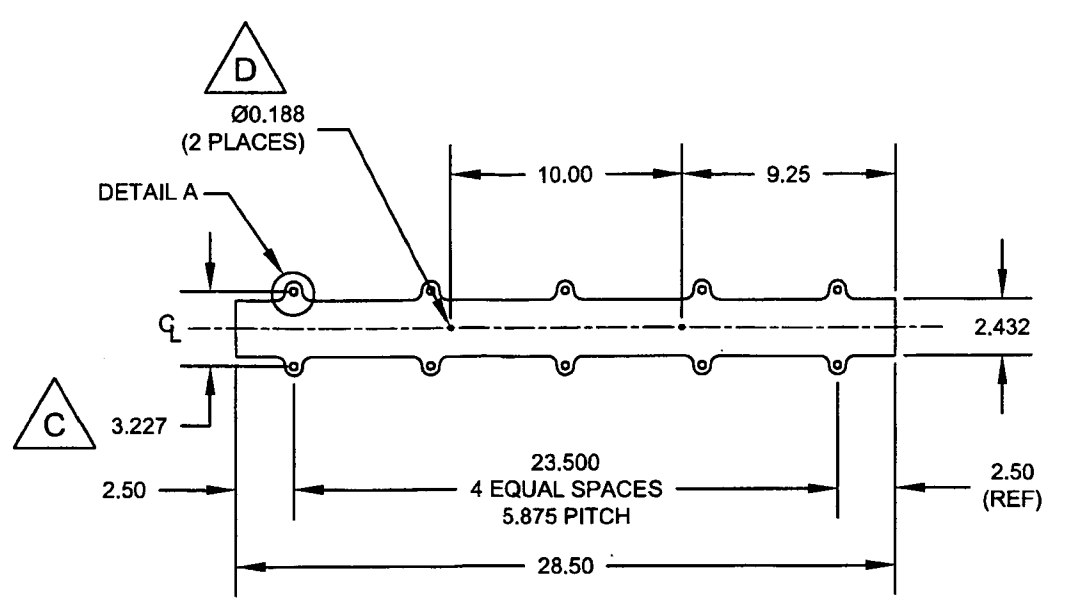
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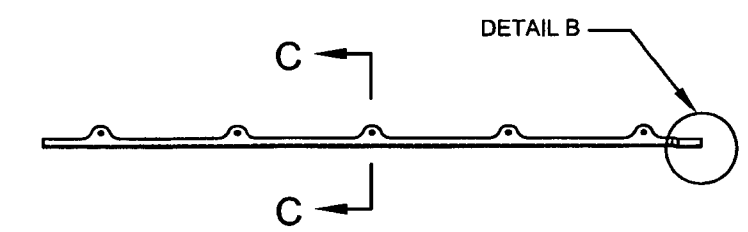
**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)



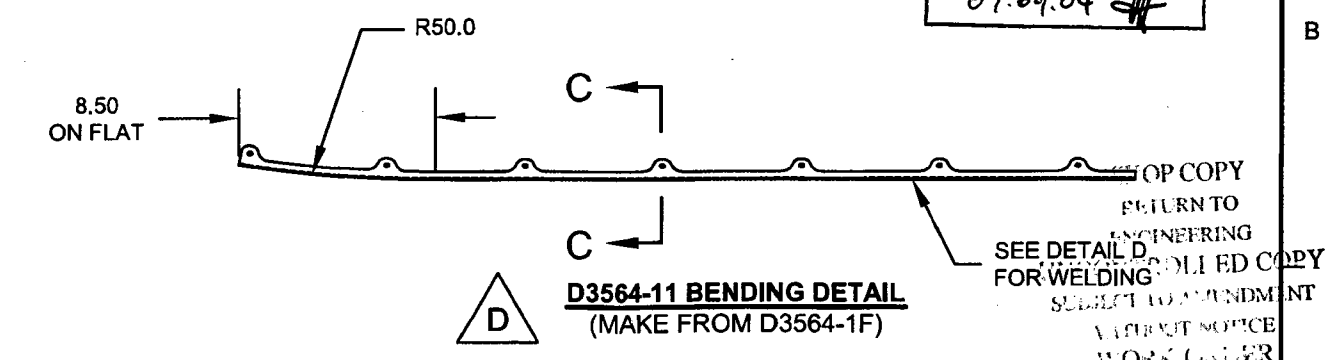
**D3564-9 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-7F FLAT PATTERN**



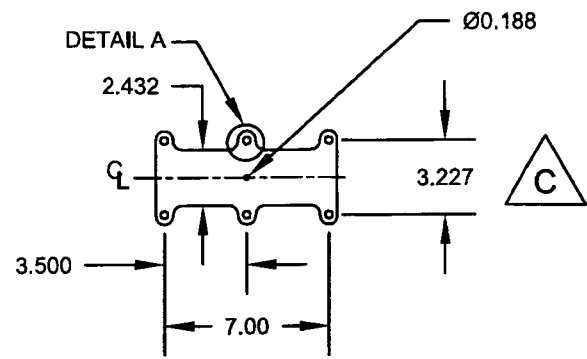
**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



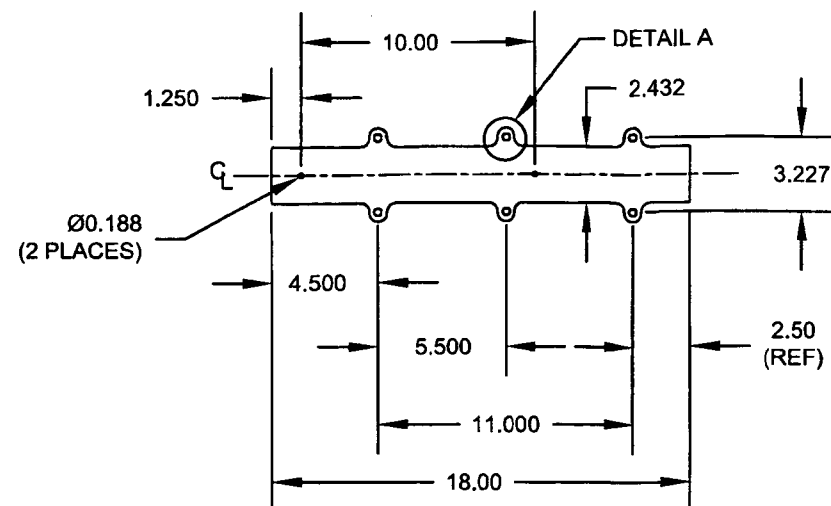
**D3564-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

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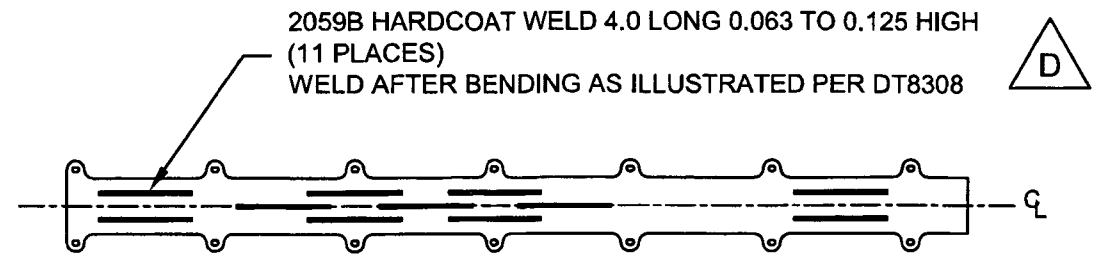
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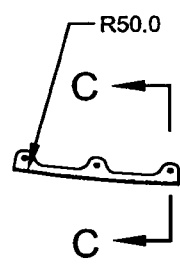
**D3564-13F FLAT PATTERN**



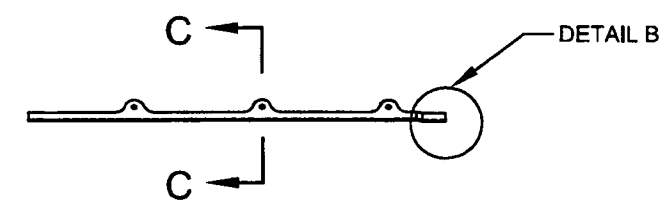
**D3564-15F FLAT PATTERN**



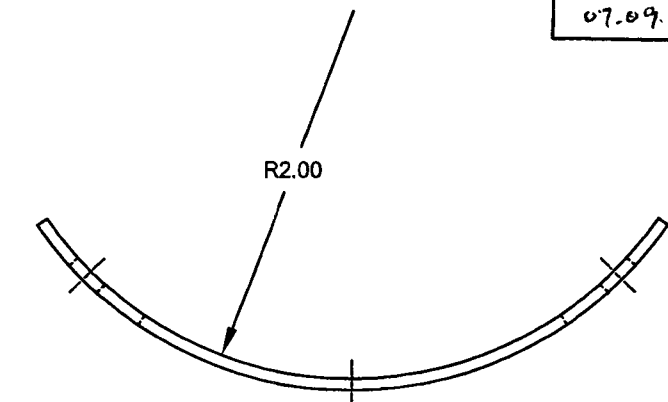
**DETAIL D**  
(D3564-1/-3/-9/-11 WELDING DETAIL)



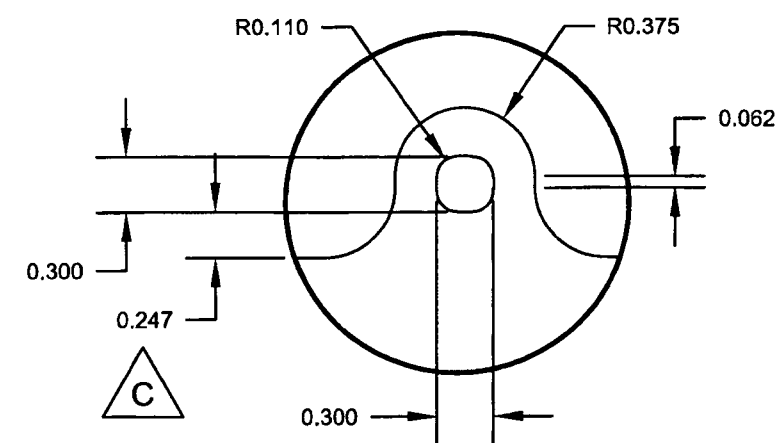
**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



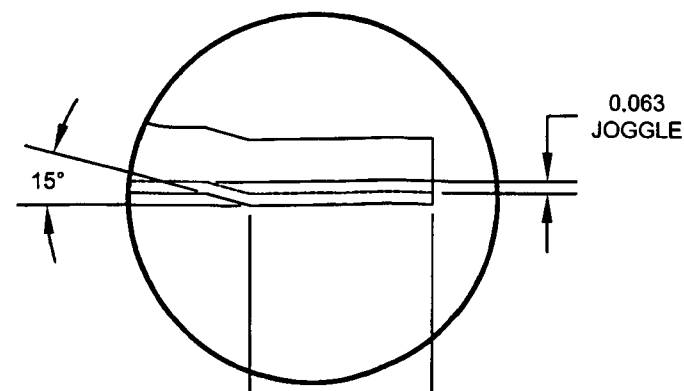
**D3564-15 BENDING DETAIL**  
(MAKE D3564-15 FROM D3564-15F)



**SECTION C-C**  
SCALE 1:1



**DETAIL A**  
SCALE 1:1



**DETAIL B**  
SCALE 1:1

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